

Date: Tuesday, 11/29/2005 7:05:36 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ALUMINUM BILLET RD
Job Number	: 25069		
Estimate Number	: 11109		
P.O. Number	: N/A	Part Number	: D6103001
This Issue	: 11/29/2005 S.O. No. : N/A	Drawing Number	: D6103 REVA
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 11/29/2005
Checked & Approved By	: <u>SEE COMMENT BELOW</u>	Qty:	20 Um: Each
Comment	: Created By Auto Work Order*!!* Late - Some of the material cannot be made in time.		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 00000200

a) Description: Aluminum round billet

b) Ø3.250" x 12.500" long

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Material: 7075-T6/T651 (QQ-A-200/11 or QQ-A-225/9)

Material certification required

Tools:

2.0

D6103001

7075-T651 3.250D x 12.5L



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

7075-T651 3.250D x 12.5L

Tools:

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for transit damage Ensure certification are attached

Tools:

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Tools:

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/29/2005 7:05:36 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ALUMINUM BILLET RD

Job Number: 25069

Part Number: D6103001

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Tools:

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/01/13

(40)

SD 06/01/18

Tools:

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Q Date: 06/01/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

COPPER AND BRASS SALES

MATERIAL TYPE

ALUMINUM ALLOYS WITH LOW BERYLLIUM

PRODUCT DESIGNATION

2014 2024 2224 2324 7050 7075 7150 7175 7475
ALUMEC 89 ALUMEC 99 QC-7

"WARNING"

SMALL CHIPS, FINE TURNINGS AND DUST MAY IGNITE READILY. EXPLOSION POTENTIAL MAY BE PRESENT WHEN: DUST OR FINES ARE DISPERSED IN THE AIR; FINE, DUST OR MOLTEN ALUMINUM ARE IN CONTACT WITH CERTAIN METAL OXIDES; OR, CHIPS, FINES, DUST OR MOLTEN ALUMINUM ARE IN CONTACT WITH WATER OR MOISTURE. KEEP AWAY FROM IGNITION SOURCE. USE EXPLOSION-PROOF VENTILATION. KEEP MATERIAL DRY.

THIS PRODUCT CONTAINS BERYLLIUM AND COPPER. INHALING BERYLLIUM DUST OR FUMES MAY CAUSE CHRONIC BERYLLIUM DISEASE (CBD), A SERIOUS CHRONIC LUNG DISEASE IN SOME INDIVIDUALS. BERYLLIUM IS A CANCER HAZARD; OVER TIME CBD AND CANCER CAN BE FATAL, TARGET ORGAN IS PRIMARILY THE LUNG. INHALING LARGE AMOUNTS OF COPPER, MAGNESIUM OXIDE, MANGANESE OXIDE, AND ZINC OXIDE FUMES OR DUST MAY CAUSE METAL FUME FEVER WITH FLU-LIKE SYMPTOMS. CHRONIC OVEREXPOSURE TO COPPER MAY CAUSE THICKENING OF THE SKIN; AND SKIN, TEETH, AND HAIR DISCOLORATION. CHRONIC OVEREXPOSURE TO MANGANESE DUST CAN CAUSE CENTRAL NERVOUS SYSTEM DAMAGE, SCARRING OF THE LUNGS AND REPRODUCTIVE HARM IN MALES. TARGET ORGAN IS PRIMARILY THE LUNG, BUT REPEATED HIGH EXPOSURE CAN ALSO AFFECT THE LIVER. CHRONIC OVEREXPOSURE TO IRON OXIDE DUST/FUME MAY CAUSE LUNG SIDEROSIS. CHRONIC OVEREXPOSURE TO SILICON DUST CAN CAUSE CHRONIC BRONCHITIS. OVEREXPOSURE TO AMORPHOUS SILICA CAN CAUSE DRYING OF THE MUCOUS MEMBRANES OF THE EYES, NOSE, AND THROAT.

THIS PRODUCT ALSO CONTAINS NICKEL AND CHROMIUM COMPOUNDS. INHALATION OF NICKEL DUST OR FUME MAY RESULT IN INFLAMMATION OF THE RESPIRATORY TRACT AND CAUSE NASAL AND/OR LUNG CANCER. NICKEL HAS BEEN IDENTIFIED AS A POTENTIAL HUMAN CARCINOGEN. EXPOSURE TO CHROMIUM DUST OR FUME MAY CAUSE METAL FUME FEVER WITH FLU-LIKE SYMPTOMS AND KIDNEY AND LIVER DAMAGE. UNDER HIGH TEMPERATURES, HEXAVALENT CHROMIUM MAY BE PRODUCED, IF IN THE INSOLUBLE FORM, IT IS A CONFIRMED HUMAN CARCINOGEN. (CALIFORNIA PROPOSITION 65).

IF COATED WITH OIL, MAY CAUSE SKIN IRRITATION/DERMATITIS BY CONTACT. WELDING FUME IS LISTED AS A POSSIBLE CARCINOGENIC TO HUMANS.

READ THE ALUMINUM/ALUMINUM ALLOYS MATERIAL SAFETY DATA SHEET(MSDS) ON FILE WITH YOUR EMPLOYER BEFORE WORKING WITH THIS MATERIAL

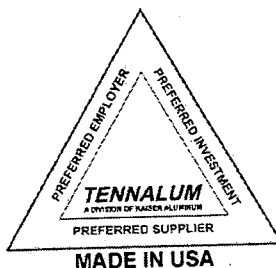
- * If processing or recycling produces particulate, use exhaust ventilation or other controls designed to prevent exposure to workers. Examples of such activities include melting, welding, grinding, abrasive sawing, sanding and polishing. Any activity which abrades the surface of this material can generate airborne particulate. Use respiratory protection (P100, quantitative fit testing required) if exposures exceed the permissible limits.
- * The Occupational Safety and Health Administration (OSHA) have set mandatory limits on occupational exposures.
- * Aluminum, in solid form and as contained in finished products presents no special health risk.
- * Sold for manufacturing purposes only. This product can be recycled; contact your sales representative.

The Occupational Safety and Health Administration require employers to provide training in the proper use of this product.

For additional information, call or write to Copper and Brass Sales, 22355 West Eleven Mile Road, Southfield, MI 48034, telephone 248-233-5600, or visit our web site @ www.copperandbrass.com.

KAISER ALUMINUM FABRICATED PRODUCTS

Tennalum
PO Box 669
Jackson, TN 38302
731-423-2811



CERTIFIED TEST REPORT
<http://KaiserEngProd.com>

CUSTOMER PO NUMBER: CH1713		CUSTOMER PART NUMBER: 024363		PRODUCT DESCRIPTION: Cold Finished Round	
KAISER ORDER NUMBER: 608694	LINE ITEM: 1	SHIP DATE: 11/07/2005		ALLOY: 7075	TEMPER: T651
WEIGHT SHIPPED: 1090 lbs.	QUANTITY: 9 pcs.	B/L NUMBER: 23817	DIAM/DAF/THKNS: 3.250 in.	WIDTH: 0.000 in.	LENGTH: 144.0 in.
SHIP TO: Copper & Brass Sales Inc 6555 E Davison Detroit, MI 48212 USA			SOLD TO: Copper & Brass Sales Inc Attn: Accounts Payable P. O. Box 5116 Southfield, MI 48086-5116 USA		

Test Code: 1000

Actual Physical Properties

Lot Number	LONG. UTS ksi	LONG. YTS ksi	LONG. ELONG. %
20071433	80.7	72.4	15.0

Chemical Composition, WT. % (Aluminum Remainder)

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	OTHERS EACH	OTHERS TOTAL
Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15
Min			1.2		2.1	0.18	5.1			

Specifications

Standard: ISO 9001, ASTM B211-03, AMS 4123G, AMS-QQ-A-225/9

Miscellaneous Notes

Made in USA

This material was melted and manufactured in the USA. Mercury is not a normal contaminant in aluminum alloys. Neither mercury nor any of its compounds were utilized by Kaiser Aluminum in the manufacture of this material. This material meets the requirements of (cold finished) T6 temper, AMS 4122J and QQ-A-225/9E (CANCELLED).

CERTIFICATION

Kaiser Aluminum & Chemical Corporation ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

John Rennekamp

Plant Serial: 60677

Kaiser Order Number: 608694

Line Item: 1



Purchase Order

Date	Page
Nov 30, 2005	1
Purchase Order Number PO00000202	

1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

Vendor Address:

Copper and Brass Sales
Postal Station A
PO Box 3453
Toronto, ON M5W 4C4
Canada
Phone (800) 926-2600

Ship To:

Main Finished Goods Locations

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-COP001	Nov 30, 2005	N30	PREPAID	Dec 09, 2005

Qty. Ordered	Item Number	Description	Drop-Ship	Unit Cost	UOM	Extended Price
20.0000	D6101013	Saddle billet B25060 PER DWG. D6101-013 REV. A DIMS: 10.100" x 8.250" x 2.50" THICK (+0.030 / -0.000) TOLERANCE ON ALL DIMENSIONS ARE +0.030"/-0.000" GRAIN DIRECTION ALONG 10.100" LENGTH MATERIAL: 7075-T7351 (QQ-A-250/12) MATERIAL CERTIFICATION REQUIRED UPON DELIVERY.	No	190.790000	Each	3,815.80
40.0000	D6103001	7075-T651 3.250D x 12.5L B2 PER DWG. D6103 REV. A DIA: 3.250" X 12.500" LONG TOLERANCES ON ALL DIMENSIONS ARE 0.030"/-0.000" MATERIAL: 7075-T6/T651 (QQ-A-200/11 OR QQ-A-225/9) MATERIAL CERTIFICATION REQUIRED UPON DELIVERY.	No	64.720000	Each	2,588.80

Comments:**Tax Summary:**

GST 448.32
GSTME 0.00
GSTND 0.00

Less:
included tax

0.00

Subtotal

6,404.60

Total tax

448.32

Entered By: LLACELLE

Total purchase order in

Approved By: _____

CAD Dollars

6,852.92